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D4131-3
Job Sheet 192447



Part No: D4131-3

Job Qty: 12 pcs

Part Name: Base



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/25/19

Job Tracking No:

Due Date: 4/30/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C SHEETS 6,7 IPP Rev:A 10.10.06 new Issue DD ver:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs		4/30/19	0.00	0.98	Waterjet - Flow		D419/04/08
120	QC 8	12 pcs		4/30/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		DAS 68
							QC 8 - 67		9-89
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
130	Small Fab - Brake NC - B4B	12 pcs		4/30/19	0.00	1.02	Small Fab - Brake - 1 - B4B		DAS 30 98 APR 1 2019
							Small Fab - Brake - 2 - B4B		
							Small Fab - Brake - 3 - B4B		

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P.T.O.

140 QC 5	12 pcs	4/30/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	DAS
				QC 5 - 30	40
				QC 5 - 40	9-89
					APR 12 2019
150 Packaging 3-1 - Stock - B4B	12 pcs	4/30/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	12 pcs	4/30/19	0.00 0.00	QC 21 - SA - 21	D&E
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89

Part Op 120 - QC8- Inspect parts - second check)
Descriptions: 130 - (Bend/Assemble as per dwg)
140 - (QC5- Inspect part completeness to step on W/O)

150 - (Identify as per dwg & Stock Location:)
160 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	1.9368 sf (.1614 ea)	100-Waterjet - Flow - 1	3055009 S1326020 S1507142
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S18GA	2	274	0
Part Specifications				
Spec No	Description	Target/Tolerance	Limits	Type
1	Base	0.098Inches	+ 0.004 - 0.001	0.102 0.097
2	Base	0.565Inches	+ 0.008 - 0.001	0.573 0.564
3	Base	1.220Inches	± 0.030	1.250 1.190
4	Base	1.380Inches	± 0.010	1.390 1.370
5	Base	1.380Inches	± 0.030	1.410 1.350
6	Base	2.750Inches	± 0.010	2.760 2.740
7	Base	3.810Inches	± 0.010	3.820 3.800
8	Base	0.530Inches	± 0.030	0.560 0.500
9	Base	4.180Inches	± 0.030	4.210 4.150
10	Base	6.100Inches	± 0.030	6.130 6.070
11	Base	0.050Inches	± 0.010	0.060 0.040

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DQA: _____ Date: _____

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐



Work Order: <u>192447</u>		AGAINST DEPARTMENT/PROCESS	
Part No. <u>D4131-3</u>		Water Jet ☒ Engineering ☐	
NCR No. <u>19-7215</u>		Prod. Eng. Coord. ☐ Quality ☐	
Date: <u>APR 10 2019</u>		Rec/Store/Packaging ☐ Other ☐	
Step #: <u>120 QC-8</u>		Supplier ☐	
Disposition		MRR (QSI042) Approval	
Description Work Order Deviation		<u>PD 19-04-12</u>	
<u>- WATER JET STARTED CUTTING A HOLE IN WRONG LOCATION.</u>		Completed By <u>DAS 68</u>	
		Lead hand / Supervisor Approval Verification <u>DAS 30 9-89</u>	
		QC / QA Coordinator Approval <u>DAS 68</u>	
		<u>APR 12 2019</u>	
FAULT CATEGORY			
Root Cause		Positioned Wrong	
Environment ☐		Outside Dimensions ☐	
Design ☐		Over/Under tolerance ☐	
Doc/Data ☐		Part Incorrect ☐	
Equip/Tooling ☐		Part Lost/Missing ☐	
Handling/Pre ☐		Part Moved ☐	
Material ☐		Drawing ☐	
Internal Transport ☐		Finish ☐	
Tribal Knowledge ☐		Misread ☐	
LOA ☐		Turning Sequence ☐	
Substation ☐			
Past Expiry Date ☐			
Misidentified ☐			
Pressure/Forced ☐		Power Loss/Surge ☐	
Bending ☐		Folio/Program ☐	
Centre Not Concentric ☐		Grain ☐	
Cracks ☐		Weld ☐	
Crimp/Kink/Ripple/Wave ☐		Wrong Stock Pulled ☐	
Cuffs ☐		Out of Sequence ☐	
Crushing ☐		Off-set ☐	
Heat Treat ☐		Mislabeled ☐	
Wave/Twist in Tube ☐		Fit/Function ☐	
Marks/Chatter ☐		Misaligned/off center ☐	
OTHER: ☐			